

Date: Wednesday, 7/4/2007 4:12:29 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS RECEIVER HOUSING	PROTOTYPE
Job Number : 33307		
Estimate Number : 12492		
P.O. Number : <i>N/A</i>	Part Number : D35143	
This Issue : 7/4/2007 S.O. No. : <i>N/A</i>	Drawing Number : UNDER REVIEW	
Prsht Rev. : NC	Project Number : <i>N/A</i>	
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : <i>N/A</i>	
Previous Run : 32536	Material : <i>N/A</i>	
Written By : <i>[Signature]</i>	Due Date : 7/11/2007	Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>		
Comment : Est Rev:A New Issue 06-07-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.4812 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *M-463321*

IB 07-07-06

CERTIFICATE OF CONFORMITY
REQUIRED

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *PREL*

Prog Rev: *PREL*

Ensure Grain Direction is correct**

2-Deburr if necessary

IB 07-07-06

MF 07-07-09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En

07/07/10

FL

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Countersink as per Dwg D3514




MF

07-07-10.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3514-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/07/10
 QA: N/C Closed: _____ Date: _____

NCR: <u>33307</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/10	# 2.0	1 Part scrap wrong mat used (0.050" instead of 0.040") R.C. Human Error		- Scrap and replace with correct correct mat. - Remind Employee to be more cautious when pulling mat. - BATCH # <u>M102723</u>	07-07-10 ES	En 07/07/10		En 07/07/10
				M100742 				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 33307

Part Number: D35143

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/10

①

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3514

SB 07/07/10

①

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FAI NEEDS MORE
DIMS.
CB 07.07.11

**ENGINEERING
APPROVAL**

07/07/10

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 PACKAGING 1 PACKAGING RESOURCE #1



FOR ENGINEERING USE ONLY

Comment: PACKAGING RESOURCE #1

07.07.19

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19

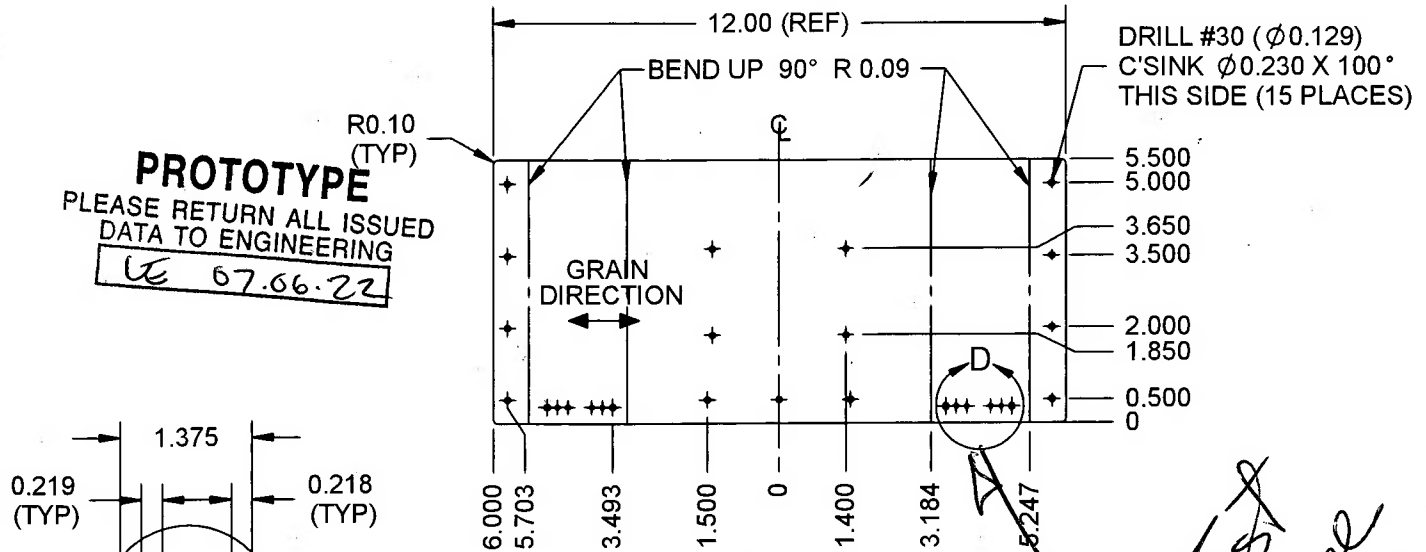
Job Completion



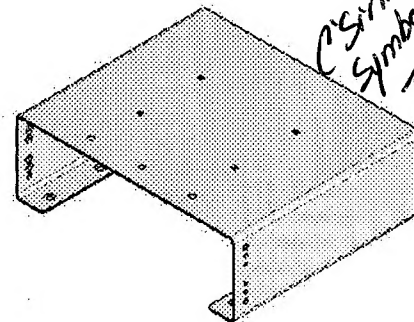
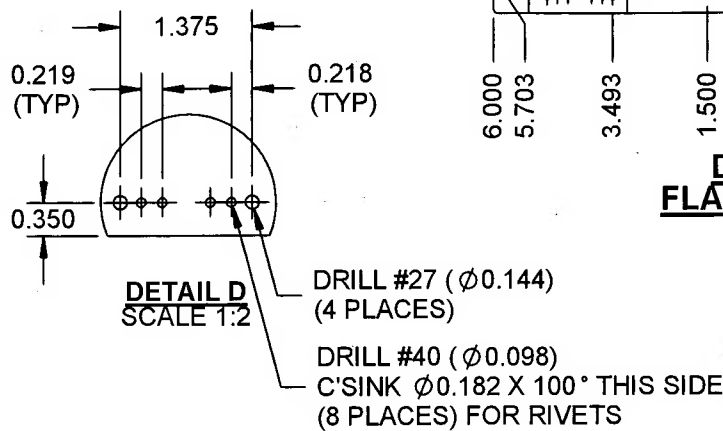
07/07/10

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3514	REV. A SHEET 6 OF 9
DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SCALE 1:4

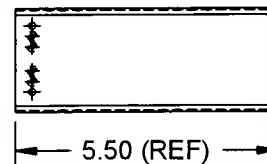
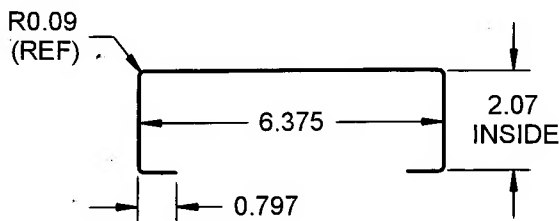
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
LE 07.06.22



D3514-3F FLAT PATTERN



Handwritten note:
C'sink
symbols
to change Done



D3514-3 BOX TOP (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT C
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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Receiving Report

Date: April 21/06
Supplier: Copper & Brass

Batch No: 1100742
Dart P/O: 1005

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr. ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☐
Shipment Complete: Yes ☐ No ☒
Q.C. Inspection ☐

Discrepancies		Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
Part No	Description					
MS0524325090	Sheet	96	0	0	96	
M6061T6B250X06000		48	0	0	48	
M6061T6B0500X0250		12	10	0	2	

ISR No: _____

Initials of receiver (if shipment OK) [Signature]

Production/Admin:

Date:

Received/Costing:

Initial:

FORM 090001 Form 1 Purchase RECEIPT rev B

Accounting:

Date:

AP/MR:

Initial:

DESCRIPTION OF MATERIAL	BILLING QTY	UNIT	PRICE	EXTENSION
RECT 6061-T6511 EXTR ALUMINUM BAR 019884 3/8 (+/- .008) X 1 (+/- .0 UZ3803 NO PROCESSING - 144" ML	1.00	PC	138.0700	138.07
GST/HST				9.66
PLEASE REMIT IN CANADIAN FUNDS				

INVOICE WILL BE DATED THE DAY OF SHIPMENT. INTEREST WILL BE CHARGED ON PAST DUE ACCOUNTS AT THE RATE OF 1-1/2% PER MONTH
PRICE SHOWN IS SUBJECT TO PRICE IN EFFECT AT THE TIME OF SHIPMENT.

G.S.T. REG. NO. 14022393

TOTAL \$

147.73

REMIT BY: 05/15/06

TERMS: NET 30 DAYS

